

Date: Thursday, 31/07/2008 2:26:36 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 40866 -1
 Estimate Number : 13489
 P.O. Number :
 This Issue : 31/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 31/07/2008 Type : SMALL /MED FAB
 Previous Run : 40711

Drawing Name : UPPER RAIL

Part Number : D37671
 Drawing Number : D3767- REVB
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 08/08/2008

Qty: 16 Um: Eac

split 4

Written By :
 Checked & Approved By : JUD 08.08.01
 Comment : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T1000W065 6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 2.9313 f(s)/Unit Total: 46.9006 f(s)
 6061T6 TUBE (1.00" x 0.65" wall)
 batch: 27102877

SAD 08/08/14

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3767

2-drill holes thru to finish size as per dwg D3767

3- deburr

QW/SAD 08/08/25

J.F. 08/08/26

08/08/25

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/27

J.F. 08/08/26

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

WZ/mf 08/08/27

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.08.22

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER RAIL

Job Number: 40866

Part Number: D37671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



47X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Store

8/8/27

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



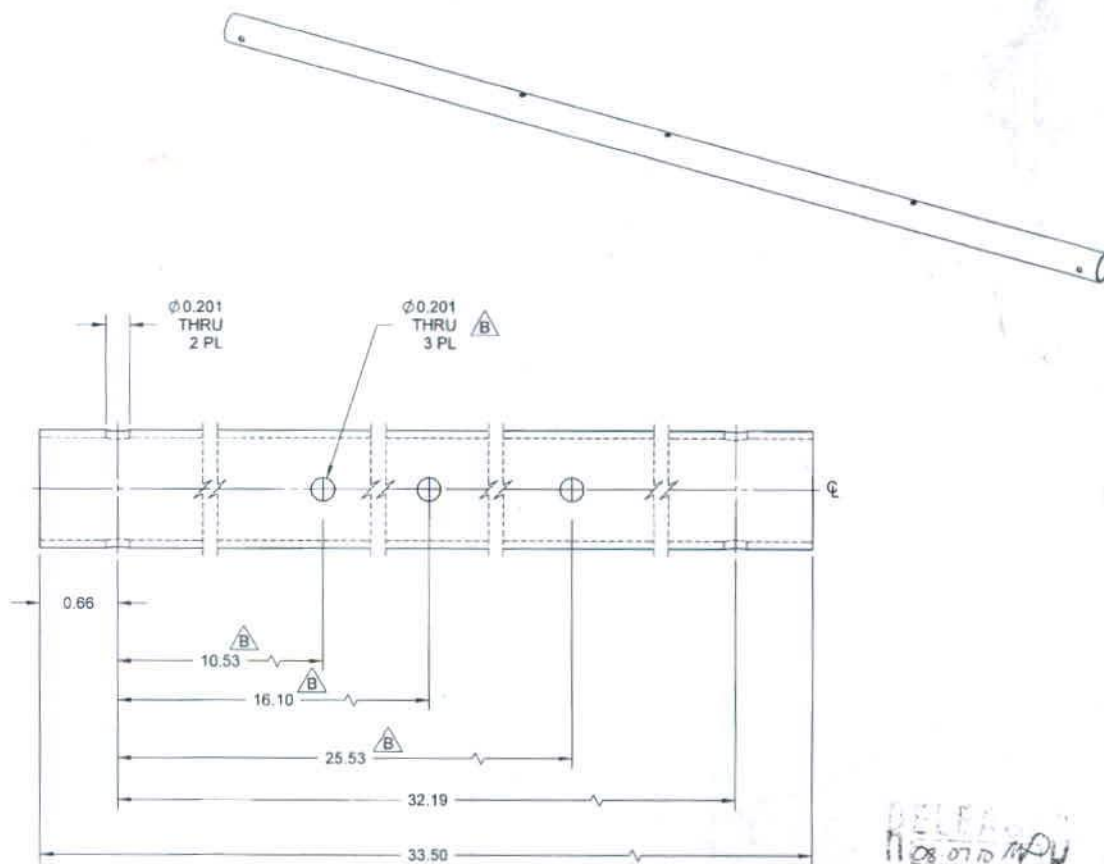
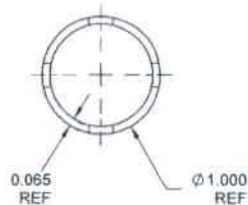
08/08/27 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



LI 8.8.27



D3767-1 UPPER RAIL

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4082 OR AMS 4082 OR QQ-A-200/8 OR AMS-QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs

REV.	DESCRIPTION	BY	DATE
B	CHANGE HOLE SIZE TO 0.201. SHIFT HOLES FOR ATTACHING FRAME BY 0.125, ADD HOLE AT 16.10	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG APPR.	HS	D3767	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	UPPER RAIL	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE REPRODUCED OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

